

REPRINT

Work Order ID 146714

May 20, 2016 2:35:47 PM

PRELIMINARY
ISSUE

146714

June 22

Item ID: D2842-044
Revision ID: PRELIM
Item Name: Step Assembly, RH, 206 Float (PHI)

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/17/2016 Start Qty: 1.00 *1*
Required Date: 6/30/2016 Req'd Qty: 1.00 *1*

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: SLT Date: 20160520 Pooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2842	PRELIM								
100	Large Fab	0.00							
100									
Large Fab	Memo	0.50							
Large Fab	1-Cut D2842-1 using D2622 extrusion as per Dwg D2842								
	2-Deburr and bevel ends for welding								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Weld per dwg A/R Aluminum rod Batch: <u>M131568</u>	0.00							
120	Large Fab								
Large Fab	Memo	0.99							
Large Fab	1-Weld one end cap and (2) lugs using Jig D10038, as per Dwg D2842								
	2-Grind end cap weld flush								

16-6-6

1 0 BE 16-06-07

1 8 BE 16-06-10

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Item ID: D2842-044 Accept *N9000040100* Setup Start *NS1*
Revision ID: PRELIM Stop *NS2*
Item Name: Step Assembly, RH, 206 Float (PHI)
Start Date: 5/17/2016 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 6/30/2016 Req'd Qty: 1.00 *1* Customer:

Reference:
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00					16-06-11		DAS 9 9-89
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02					16-06-11		DAS 9 9-89
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.49					16-6-13		

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Item ID: D2842-044
Revision ID: PRELIM
Item Name: Step Assembly, RH, 206 Float (PHI)

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Start Date: 5/17/2016 Start Qty: 1.00 ***1***
Required Date: 6/30/2016 Req'd Qty: 1.00 ***1***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.01				1	0	BE 16-06-13	
170 *170* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>rn131362</u> Large Fab Memo 1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.	0.00 1.49				1	0	BE 16-06-13	
180 *180* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				①		16-06-14	

DAS
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Item ID: D2842-044
 Revision ID: PRELIM
 Item Name: Step Assembly, RH, 206 Float (PHI)
 Start Date: 5/17/2016 Start Qty: 1.00
 Required Date: 6/30/2016 Req'd Qty: 1.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.02							
Quality Control									
191	Pressure Wash per QSI005 4.3	0.00							
191									
HandFinish	Memo	0.16							
Hand Finishing	***Touch up step with alodine per qsi 005 prior to powder coat***								
200	Spray Painting per QSI005 4.2	0.00							
200									
SprayPaint	Memo	0.14							
Spray Painting	SPRAY PAINT AS PER NOTE 2								

Primer 135429
 Paint 135519

DAS
 9
 9-89

DAS
 41
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17-1-16

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Item ID: D2842-044

Accept

N900040100

Setup

Start

NS1

Revision ID: PRELIM

Stop

NS2

Item Name: Step Assembly, RH, 206 Float (PHI)

Start Date: 5/17/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/30/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC14- Inspect Spray Paint	0.00							
210									
QC	Memo	0.01							
Quality Control									
220	HandFinishing	0.00							
220									
HandFinish	Memo	0.66							
Hand Finishing									
	2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: <u>21136706</u>								
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.02							
Quality Control									

DAS
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JAN 19 2017

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Item ID: D2842-044 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Step Assembly, RH, 206 Float (PHI)
Start Date: 5/17/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/30/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Identify as per dwg & Stock Location: <u>PK</u>	0.00							
240									
Packaging	Memo	0.01							
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.10							
Quality Control									

MAR 13 2017
DAS
6
9-89
12/3/14

OAS
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9-89

MAR 13 2017

Picklist Print

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Page 1

Work Order ID: 146714

146714

Parent Item: D2842-044

D2842-044

Parent Item Name: Step Assembly, RH, 206 Float (PHI)

Start Date: 5/17/2016

Required Date: 6/30/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 16-05-19 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C		Manufactured	No				Each	72.2360		1			
D2622-120C Step Extrusion													

Location Loc Qty Loc Code

WA003

0.236

130161

0.236

WA004

72

140539

72

D2734

Manufactured No

Each

40.0000

2

D2734

Step End Plate

Location Loc Qty Loc Code

WA003

40

134415

30

141034

10

D3459-1

Manufactured No

Each

36.0000

2

D3459-1

Float Step Mounting Plate

Location Loc Qty Loc Code

WA003

36

130490

15

132719

9

134950

12

Picklist Print

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Work Order ID: 146714

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Parent Item: D2842-044

D2842-044

Parent Item Name: Step Assembly, RH, 206 Float (PHI)

Start Date: 5/17/2016

Required Date: 6/30/2016

Start Qty: 1.00

Required Qty: 1.00

D3459-3

Manufactured No

Each

34.0000

2

D3459-3

Float Step Mounting Plate

**

BE16-06-07

Location

Loc Qty

Loc Code

WA003

34

129735

2

130491

20

134882

12

2

A

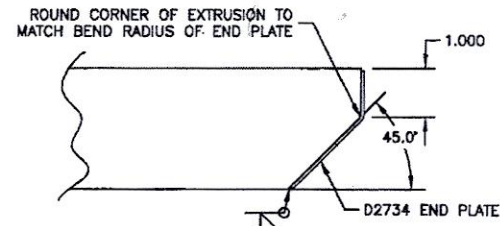
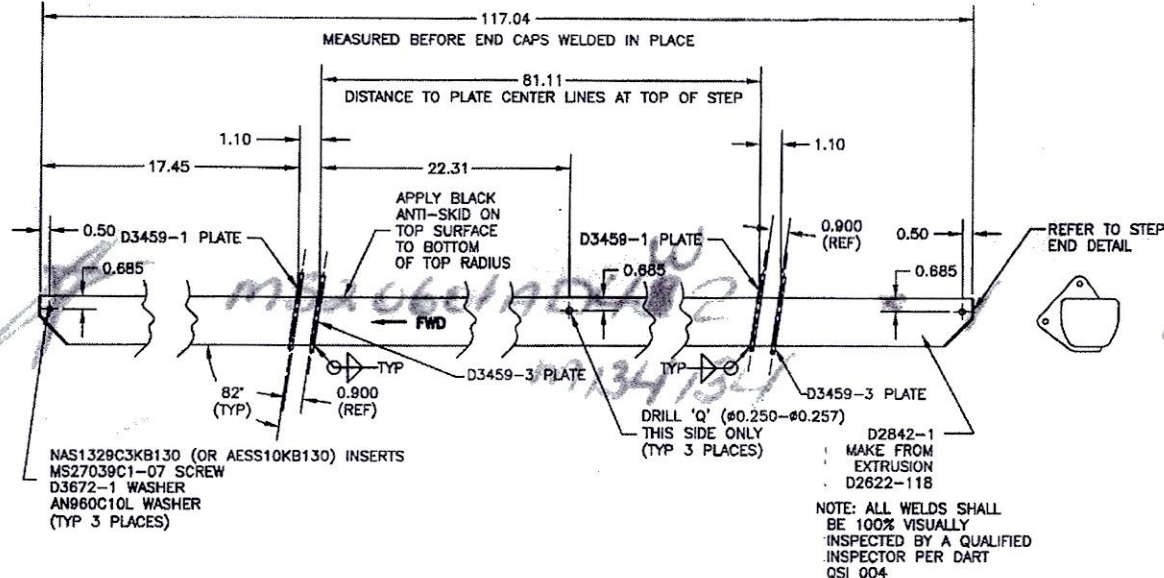
MS20601AD4^W2

x 1

M134134

BE16-06-013

Qty	Qty	Part Number	Description
041	042		
X	X	D2842-041	LH FLOAT STEP ASSEMBLY
X	X	D2842-042	RH FLOAT STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	D3672-1	WASHER
3	3	MS27039C1-07	SCREW
3	3	NAS1148C0332R	WASHER (AN960C10L)
3	3	NAS1329C3KB130	INSERT (or AESS10KB130)



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041 LH FLOAT STEP ASSEMBLY (SHOWN)
D2842-042 RH FLOAT STEP ASSEMBLY (OPPOSITE)

NOTES:

- 1) MATERIAL: MAKE FROM EXTRUSION D2622
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2842-041/-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

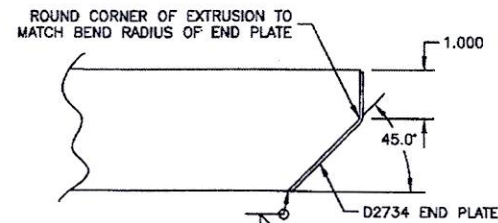
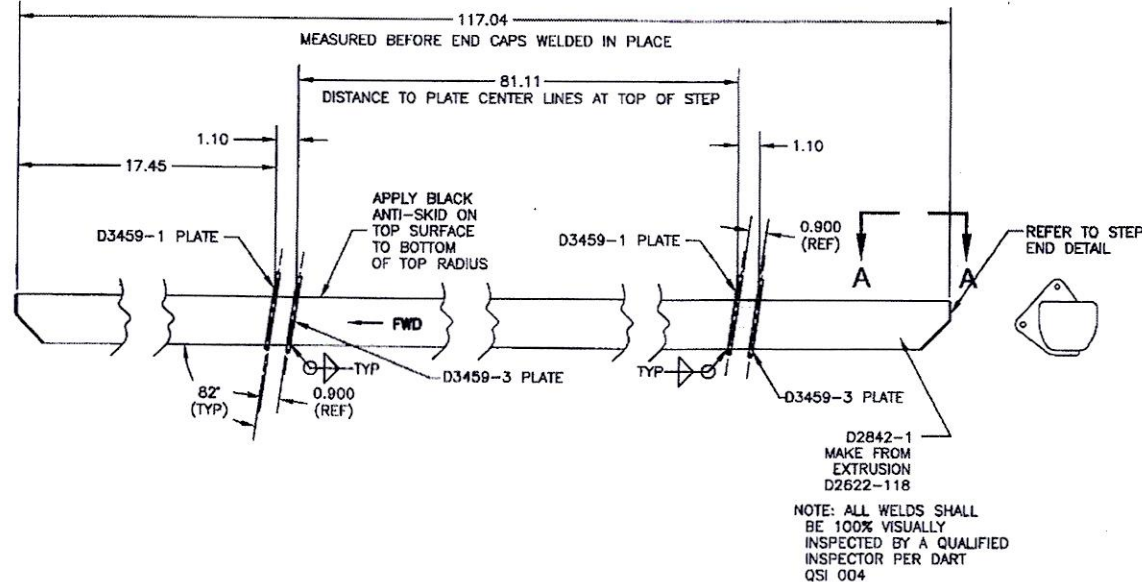
20160520

146714

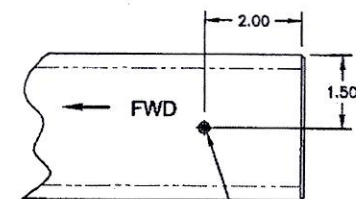
PRELIMINARY # 20605.6

C	ADD -043/-044 (FOR PHI) FORMATTED TO CURRENT STANDARD	DS	16.04.25
B	RE-DESIGN, ADD D3459-1/-3	PH	98.10.13
A	NEW ISSUE	KE	98.10.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. C
MFG. APPR.	DD	D2842	SHEET 1 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	206/407 FLOAT STEP ASSEMBLY	NTS
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Qty	Qty	Part Number	Description
X	X	D2842-043	LH FLOAT STEP ASSEMBLY (FOR P/N)
X	X	D2842-044	RH FLOAT STEP ASSEMBLY (FOR P/N)
1	1	D2822-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
1	1	MS20601AD4W2	RIVET



TYPICAL STEP END DETAIL
NOT TO SCALE



Ø0.129, CSK Ø0.225 x 100°
OPTIONAL VENT HOLE FOR WELDING
LOCATE ON THIS SURFACE
PLUG WITH MS20601AD4W2 RIVET
AFTER WELDING PRIOR FINISH

SECTION A-A
NOT TO SCALE

D2842-043 LH FLOAT STEP ASSEMBLY (SHOWN)
D2842-044 RH FLOAT STEP ASSEMBLY (OPPOSITE)

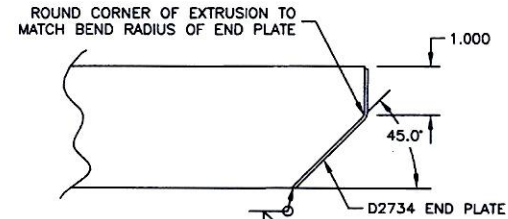
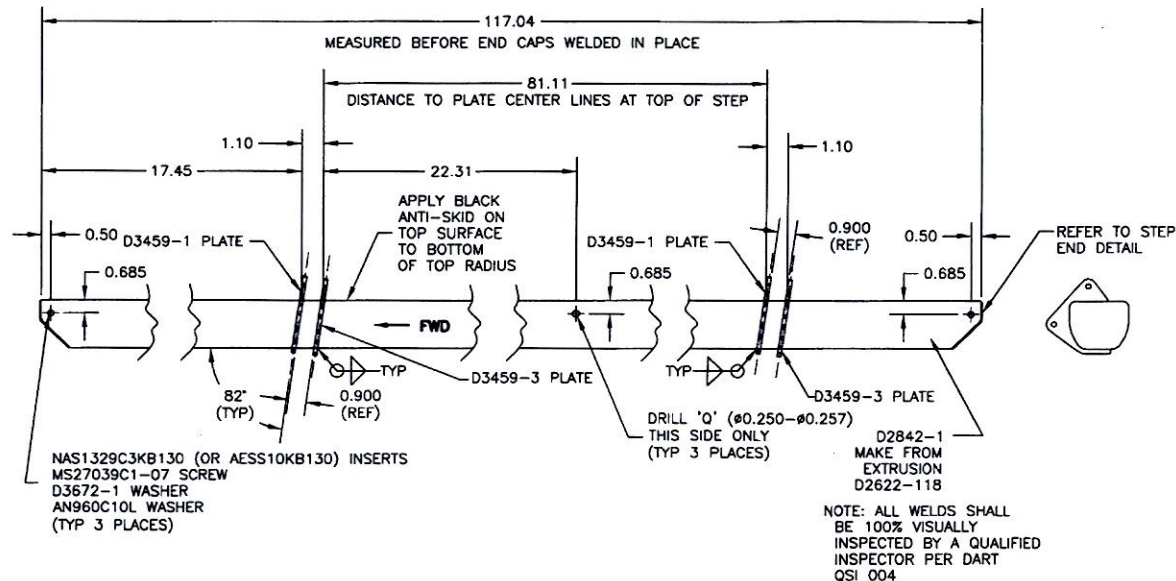
NOTES:

- 1) MATERIAL: MAKE FROM EXTRUSION D2822
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME (REF 4.2.1.3.3) OUTSIDE PER QSI 005 4.2.1
PAINT BLACK PER QSI 005 4.2.2 USING CA8213/F37038 CAMOFLAGE BLACK PER MIL-PRF-05285E TYPE I CLASS H
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2842-043/-044" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

DESIGN	KE	DART AEROSPACE USA, INC	
DRAWN	RF	EUGENE, OR	
CHECKED	AK	DRAWING NO.	REV. C
MFG. APPR.	DD	D2842	SHEET 2 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.		206/407 FLOAT STEP ASSEMBLY	NTS
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PRELIMINARY # 206.05.16

Qty -041	Qty -042	Part Number	Description
X	X	D2842-041	LH FLOAT STEP ASSEMBLY
X	X	D2842-042	RH FLOAT STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	D3672-1	WASHER
3	3	MS27039C1-07	SCREW
3	3	NAS1149C0332R	WASHER (AN960C10L)
3	3	NAS1329C3KB130	INSERT (or AESS10KB130)



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041 LH FLOAT STEP ASSEMBLY (SHOWN)
D2842-042 RH FLOAT STEP ASSEMBLY (OPPOSITE)

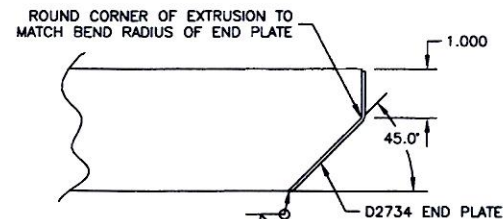
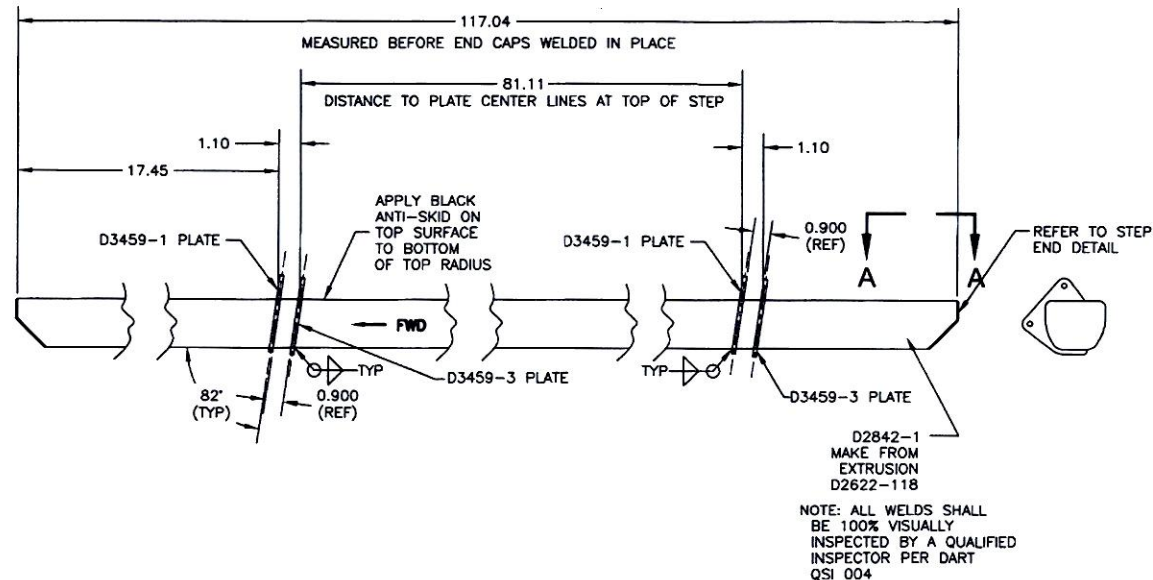
NOTES:

- 1) MATERIAL: MAKE FROM EXTRUSION D2622
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2842-041/-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

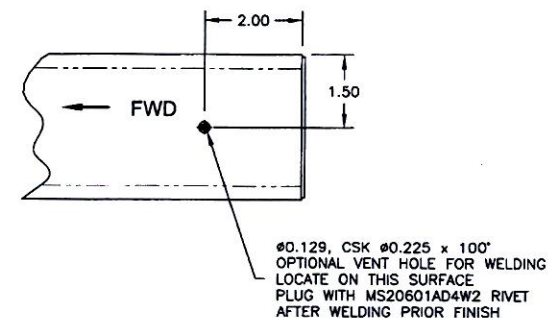
RELEASED
2016-08-02
EN 4-620

C	ADD -043/-044 (FOR PHI)	DS	16.04.25
B	RE-DESIGN, ADD D3459-1/-3	PH	98.10.13
A	NEW ISSUE	KE	98.10.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. C
MFG. APPR.	DD	D2842	SHEET 1 OF 2
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Qty -043	Qty -044	Part Number	Description
X	X	D2842-043	LH FLOAT STEP ASSEMBLY (FOR PHI)
		D2842-044	RH FLOAT STEP ASSEMBLY (FOR PHI)
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
1	1	MS20801AD4W2	RIVET



TYPICAL STEP END DETAIL
NOT TO SCALE



SECTION A-A
NOT TO SCALE

D2842-043 LH FLOAT STEP ASSEMBLY (SHOWN)
D2842-044 RH FLOAT STEP ASSEMBLY (OPPOSITE)

NOTES:

- 1) MATERIAL: MAKE FROM EXTRUSION D2622
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME (REF 4.2.1.3.3) OUTSIDE PER QSI 005 4.2.1
PAINT BLACK PER QSI 005 4.2.2 USING CA8213/F37038 CAMOFLAGE BLACK PER MIL-PRF-05285E TYPE I CLASS H
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2842-043/-044" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

RELEASED
2016-08-02

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DRAWN	RF	EUGENE, OR	
CHECKED	AK	DRAWING NO.	REV. C
MFG. APPR.	DD	D2842	SHEET 2 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.	4	206/407 FLOAT STEP ASSEMBLY	NTS
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